






**Work Order ID 73422**

Page 1

Wednesday, August 31, 2011 3:16:42 PM

Item ID: D3793-1      Accept            Setup      Start        
Revision ID:      Stop        
Item Name: Wearshoe  
Start Date: 8/31/2011      Start Qty: 12.00            Cust Item ID:  
Required Date: 9/16/2011      Req'd Qty: 12.00            Customer:  
Reference:

Approvals:      Process Plan: CD      Date: 11/09/01      Tooling:      Date:      Run      Start        
QC:      Date:      SPC (Y/N):      Date:      Stop      

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3793	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793      ☐ Dwg Rev: A      ☐ Prog Rev: A      ☐ 2-  
Deburr if necessaryB11-9-19

(14)

304 . 040

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-19

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulorke

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73422

Wednesday, August 31, 2011 3:16:42 PM



Page 2

Item ID: D3793-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Wearshoe				
Start Date: 8/31/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 9/16/2011	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00				(14)			
	Brake NC								
	Memo	0.00							
	1-Deburr if necessary <input type="checkbox"/> 2-Form on Brake as per Dwg D3793 using Jigs <input type="checkbox"/> 3-Form Joggle on brake using Jig as per Dwg D3793								

140	QCS- Inspect part completeness to step on W/O	0.00				(74)			
	QC								
	Memo	0.00							
	Quality Control								

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
	Powdercoat								
	Memo	0.00							
	START TIME: <del>12:30</del>								
	POWDER COATING: <del>12:30</del>								
	FINISH TIME: <del>12:30</del>								

MU7338

3200F

12:30  
12:30

14X DM 11/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73422

Wednesday, August 31, 2011 3:16:42 PM



Page 3

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/31/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				14 cxmoh	0	11	u109/20
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>F-P 1</u>  Memo	0.00  0.00							14x0 M-11/09/20
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							u109/21 ME 11-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 3:16:40 PM

Page 1

Work Order ID: 73422

Parent Item: D3793-1

Parent Item Name: Wearshoe



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

212.4072

0.5902

7.455158

8.5



81-9-19

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

212.4072

116623

0.2

117550

9.363

117933

79.3442

118400

123.5

118400

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73422
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3793-1
<b>Inspection Dwg:</b> D3793 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

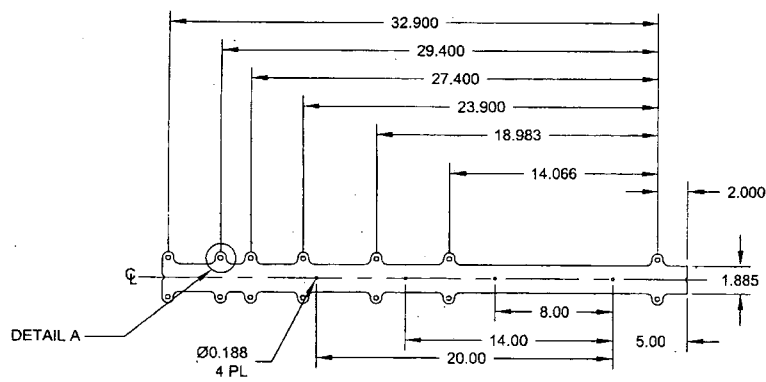
☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.191	✓		V B02	
0.300 x 0.300	+/-0.010	299.501	✓		V	
1.885	+/-0.010	1.889	✓		V	
2.000	+/-0.010	2.000	✓		V	
5.00	+/-0.030	5.00	✓		T B01	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.00	✓		T	
20.00	+/-0.030	20.00	✓		T	
14.066	+/-0.010	14.066	✓		T	
18.983	+/-0.010	18.983	✓		T	
23.900	+/-0.010	23.900	✓		T	
27.400	+/-0.010	27.400	✓		T	
29.400	+/-0.010	29.400	✓		T	
32.900	+/-0.010	32.900	✓		T	
0.040	+/-0.010	.037	✓		V	

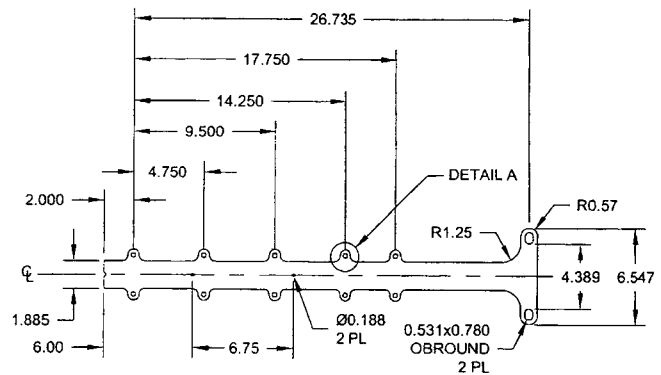
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-9-19	<b>Date:</b> 11/09/19	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.05.30	New Issue	KJ/DD	

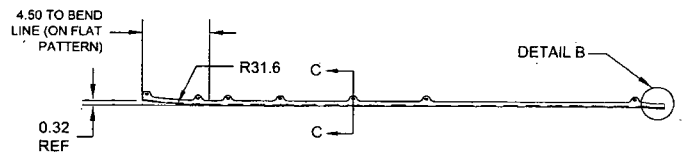
8 7 6 5 4 3 2 1



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73422

*C21109/01*

**RELEASED**  
*08.05.14*

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
  - 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

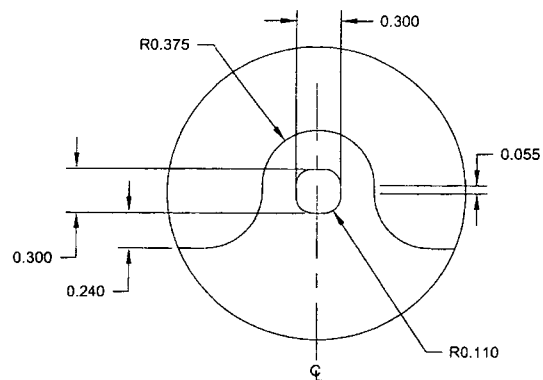
  

<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA		REV. A
DRAWING NO.	D3793	SHEET 1 OF 2
TITLE	WEARSHOE	SCALE
		NTS

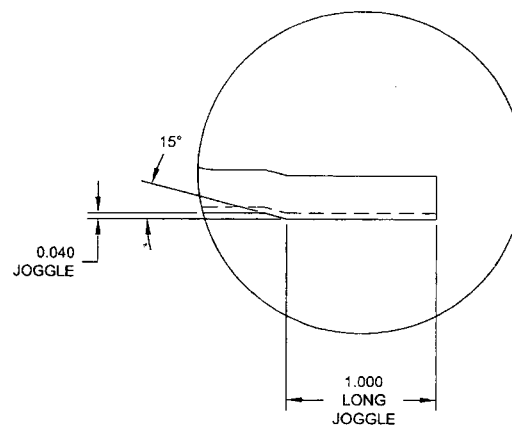
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8 7 6 5 4 3 2 1

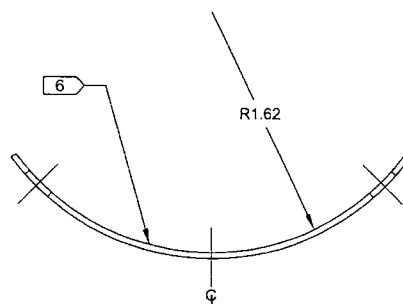
D  
C  
B  
A



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-14

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1